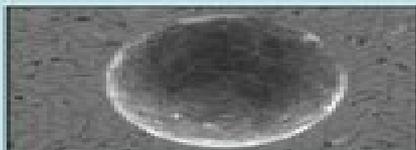


Hydrogen Blowhole



Possible causes:
 High moisture content in charge or alloy materials
 Inadequate degassing
 High content of aluminium or silicon
 High level of sulphur in moulding sand
 High level of oil in ladle
 Wet mould or core casting
 Poor or worn ladle refractory and/or furnace refractory materials

Nitrogen Fissure



Possible causes:
 Use of high steel scrap content in melts melted over
 excessive nitrogen
 Use of materials with high nitrogen content
 High level of nitrogen in the ladle (indicated by an increase in
 nitrogen flow volume)

Compaction of Graphite Flakes



Possible causes:
 Excessive furnace treatment by heavy oxidation, often in
 association with nitrogen fixation
Possible cures:
 Reduce all nitrogen content in materials melted from
 with high steel charges
 Use of materials with high nitrogen content
 Reduction of the steel temperature to the level of
 nitrogen in the melt
 Reduction of the gas content by controlled base nitrogen

Shrinkage



Possible causes:
 High levels of not properly cooled metal
 Excessive cooling rate in casting
 Hot spots resulting from uneven distribution and
 hot metal resulting from uneven distribution and
 casting design involving large changes in casting section
 Size of castings

Slag Entrapment



Possible causes:
 Inadequate slag removal during melting and pouring
 Excessive flow velocity with turbulence
 Lack of slag traps or filters
 Use of worn ladle refractory and/or furnace refractory
 Excessive addition of alloy forming inclusions
 Excessive pouring height

Carbon Monoxide Blowhole



Possible causes:
 High sulphur in composition with high temperature content
 Excessive gas evolution
 Excessive slag entrapment
 Use of worn ladle refractory and/or furnace refractory leading to
 large loss of iron
Note: Carbon monoxide blowholes are also caused by the
 manganese sulphide blowhole

Intercellular Carbide



Possible causes:
 Excessive use of alloying elements providing elements
 such as Cr, V, Ti, and Nb
 Low levels of graphite following elements such as Si
 and Mn in base metal
 Low solidification rate
 Superheating and long holding of base iron
 Too high amount of steel scrap in the charge

Steadite



Possible causes:
 Excessive high phosphorus content
 Too high sulphur in base metal
Note: High phosphorus content also increases the
 likelihood of sulphur and carbon in the iron

Undercooled Graphite



Possible causes:
 High pouring temperature
 Rapid solidification
 Excessive cooling during moulding of metal prior to pouring
 High content of sulphur
 Low content of graphite

C Type Graphite



Notes: Undercooled graphite, is mainly found in iron with higher
 sulphur content
Possible causes:
 High pouring temperature
 Rapid solidification
 Excessive cooling during moulding of metal prior to pouring
 High content of sulphur
 Low content of graphite

Widmanstätten Graphite



Possible causes:
 High content of base elements such as Fe,
 Si and Mn
 Effect seen in thicker sections subject to slower cooling
 rate and segregation

Ferritic Rim



Possible causes:
 Too low content of graphite in generalised moulds
 Underheating
 Over solidification
 Low pouring temperature

Elkem produces a comprehensive range of inoculants for the manufacture of grey cast irons. These are suited to most application methods, ladle inoculation, in-stream inoculation or by addition in a wire.

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Superspeed[®] 75 or **Superspeed[®] 50** inoculants. The most widely used inoculant for grey irons of medium to high sulphur content. The low addition rates necessary to achieve maximum chill reduction mean that the iron is less prone to shrinkage.

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Common Metallurgical Defects In Grey Cast Irons

RJ Alexander



Common Metallurgical Defects In Grey Cast Irons:

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